

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018106**Date Inspected:** 09-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

TOWER JETTY

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of weld joint # 06 located on West tower Lift-4 Skin 'E', 119 M Backfill plate WSD1 – FESA4 – 4B/F as per the weld repair report # T-WR3742. Welder is identified as 040690. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – Repair – 1.

Weld joint # 27 located on East tower Lift-4 Skin 'A', 119 M Backfill plate ESD1 – FASA4 – 2B/E. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4214 – Tc – U4c – 4.

Weld joint # 29 located on South tower Lift-4 Skin 'A', 119 M Backfill plate SSD1 – FASA4 – 1B/E. Welder is identified as 040582. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4313 – Tc – P4.

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Weld joint # 29 located on North tower Lift-4 Skin 'A', 119 M Backfill plate NSD1 – FASA4 – 1B/E. Welder is identified as 057220. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4313 – Tc – P4.

Repair welding of weld joint # 07 located on East tower Lift-4 Skin 'E', 119 M Backfill plate ESD1 – FESA4 – 2B/F as per the weld repair report # T-WR3742. Welder is identified as 202354. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – Repair – 1.

Visual Inspection Testing (VT) For Diaphragm Gratings Of Lift-3 Tower Shafts

This QA inspector performed VT for diaphragm gratings at elevations 102 M and 105 M on North, East, West and South shafts of lift-3 after ZPMC personnel completed the repair work as per the RFI-ZPM-00891R00. This area was previously tested and accepted by ZPMC/ABF Quality Control personnel. The member is identified as TOWER Component.

For further information see the attached pictures of East tower lift-3 (Typical).

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 16A located on Lift-5 bracket ND1 – BRSA5 – 2. Welder is identified as 040724. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – TC – U5b.

Weld joint # 6B located on Lift-5 bracket SD1 – BRSA5 – 1. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – TC – U5b.

Weld joint # 1A located on Lift-5 bracket ND1 – BRSA5 – 2. Welder is identified as 040724. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – TC – U5b.

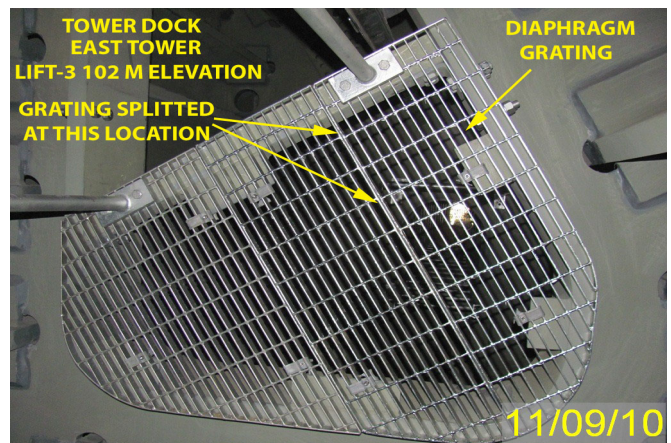
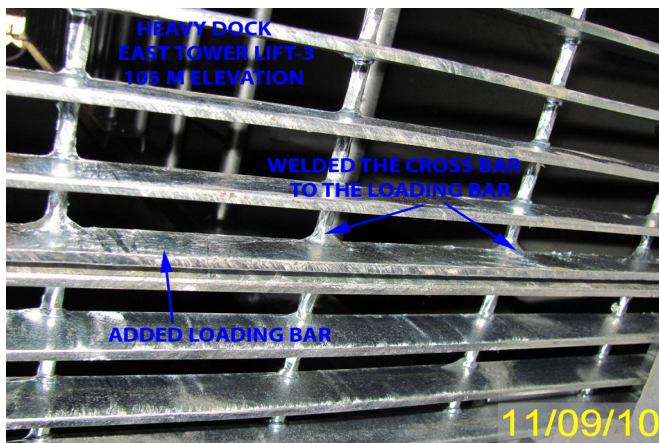
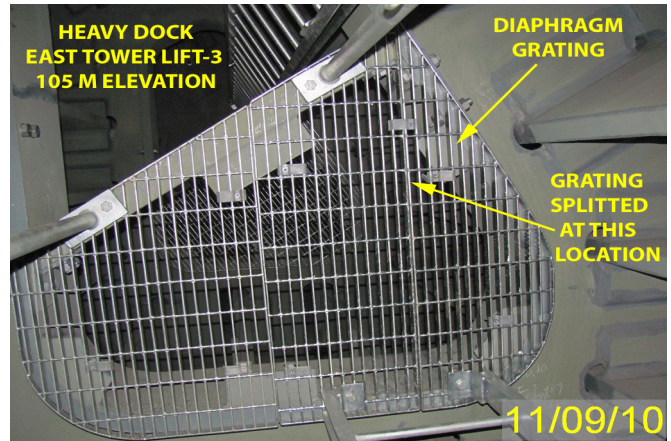
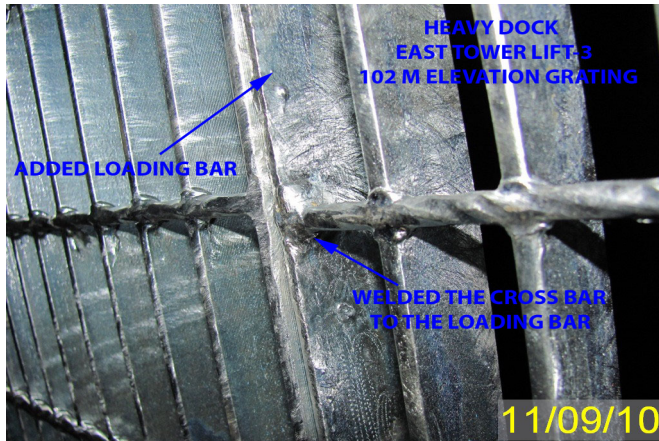
Fluxcored Arc Welding (FCAW):

Weld joint # 06 located on Lift-6 Tower Head of skin 'A' ESD1 – FASA6 – 2. Welder is identified as 053316. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho- 15002048250, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer